



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2806-3
Job Sheet 169881



Part No: **D2806-3**

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Customer: Transport Canada (CTRAN06)

Accounts Payable, Unit AFFA, 330 Sparks Street Ottawa, ON, K1V 0N5 Canada ph:(613) 998-3145

Note: DWG REV A IPP: B 05.03.11 Part now turned KJ/JLM IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-1		<i>18/01/20</i>
100	Doosan	20 pcs	1/11/18	1/11/18	0.00	1.73	Doosan		<i>18/01/20</i>
120	QC	20 pcs	1/11/18	1/11/18	0.00	0.00	QC8		<i>18/01/20</i>
130	HandFinish	20 pcs	1/12/18	1/12/18	0.00	0.30	HandFinish1		<i>2018/01/22</i>
140	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC7-1		<i>38</i>
150	Packaging	20 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1	<i>5704</i>	<i>AT 18/01/22</i>
160	QC21-SA	20 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1- Turn as per Folio FA105 Rev: _____ & Dwg D2806 Rev: _____

21 JAN 23 2016
S-00 21 JAN 23 2016
S-03

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6H1.000	2	10	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	1.000Inches ± 0.010	<i>1.003</i> 1.010 0.990		
2	Bushing	1.155Inches ± 0.010	<i>1.145</i> 1.165 1.145		
3	Bushing	0.250Inches ± 0.010	<i>0.242</i> 0.260 0.240		
4	Bushing	0.063Degrees ± 0.010	<i>0.053</i> 0.073 0.053	Angle	
5	Bushing	45.000Inches ± 0.000	<i>45°</i> 45.000 45.000		
6	Bushing	0.080Inches ± 0.010	<i>0.075</i> 0.090 0.070		
7	Bushing	45.000Degrees ± 0.000	<i>45°</i> 45.000 45.000	Angle	
8	Bushing	0.495Inches	<i>0.493</i> 0.495		

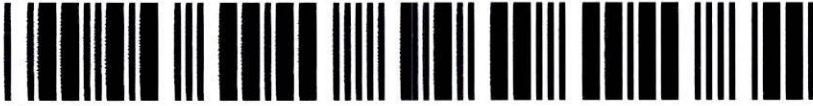
			+ 0.000		0.490	
			- 0.005			
9	Bushing	0.750Inches	+ 0.000 - 0.005	0.748	0.750 0.745	Diameter
10	Bushing	0.316Inches	+ 0.005 - 0.001	0.318	0.321 0.315	Diameter
11	Bushing	0.094Inches	± 0.010	0.092	0.104 0.084	

Plex 1/3/18 8:14 AM dart.poulin.mario



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Bushing

PART NO: D2806-3

Original Serial #: S034003

Revision:

Operation: Start up Operation 01/20/18

Change No:

Job No: 169881

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D2806-3 Revision: Bushing														
160	QC21-SA	S034003	169881	20 Ea	0	S034003	ST011	Bin	Stock	1/20/2018	Issue Container			
Operation Totals:		1		20	0									
Part Totals:		1		20	0									
Part Number: M6061T6H1.000 Revision: 6061-T6 Hexbar 1.00														
100	Receive Ft	S033176	169881	3 ft	0	m136687	MAT017		Stock	1/18/2018	Issue Container			
		S034000	169881	0 ft	0	m136687	Start Up Machining-1		Stock	1/20/2018	Issue Container			
Operation Totals:		2		3	0									
Part Totals:		2		3	0									
Totals:		3		23	0									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								